Work Order I March-07-14 3:34:1		due	*114	1487*						Page 1	
Item ID: D34 Revision ID: Item Name: Lug	14-041		Accept	*N900	040	100)* ፡	Setup Sta Sto	· I VI	S1* S2*	
Start Date: 07/0 Required Date: 28/0 Reference:	3/2014 Start Qty: 24.0 3/2014 Req'd Qty: 24.0	7 —		Cust Item I Customer:	D:						
	ocess Plan:	Date: 14.03.10	Tooling: SPC (Y/N):	· · · · · · · · · · · · · · · · · · ·	ate:		. F	Run Star Sto	/I \^	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr D3414	Revision Nbr Rev C										-
1 \\n Waterjet FLOW CNC Waterjet	Memo 1-Cut as Dwg Re ¹ Prog Re ¹		0.00				24	, O		In 14-03	,,-76
110	2-Debur QC2- Inspect parts of	r if necessary ff machine FAI/FAIB	0.00				÷				
110 QC Quality Control	Мето		0.00				24	•	-	Jm 14-c	75-2

DQA:		Date	e:						_			DART
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					DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
Work Orde	er:					.				· · · · · · · · · · · · · · · · · · ·	_	, ,
					Rework			⊢	stube		Water Jet	Engineering
Part N	۱o				Scrap			~ —	II Fab	4	d. Eng. Coor.	Quality
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Root				Desc	ription of work order update		Initial	Action		Sign &		
Cause	Da	ite Ster	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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	_	re Not Cond	centric		BOM/Route		Grain	108:4111		Over/Under		Set-up
	Crac				Broken/Damage/Defect	-	Hardwa	are		Part Incorred	<u> </u>	Temperature/Cure
	lacksquare	p/Kink/Rip	ole/Wave		Burrs	\vdash	┪	ion Incomplete/Unqualifie	_d	Part Lost/Mi	<u> </u>	Weld
	Cuff				Contamination		1	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		hing			Countersink		-1	gned/off center		Positioned V	ـــــ √rong	_
	Hea	Treat			Cut Too Short		Mislab	-		Power Loss/:	Surge	Other
	Insp	ection Strip	in Tube		Drawing		Misrea	d		•		
	Mar	ks/Chatter			Drill Holes		Off-set					177 A 17
3	Turr	ing Sequen	ce		Finish		Out of	Calibration				
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Work Orde March-07-14 3.		4487			*114	487*							Page 2	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3414-041 Lug 07/03/2014 28/03/2014	Start Qty: 24.00 Req'd Qty: 24.00		*24* *24*	Accept	*N900 Cust Item Customer:		100)* s	Setup S	tart top		S1* S2*	
Approvals:	Process Pla	n:	Date:		Tooling:	D	ate:	_	R		tart	*NI	⊋ 1*	
	QC:		Date:_		SPC (Y/N):	D	ate:			S	top	*NI	32*	
Sequence ID/ Work Center II 120 *1 20* QC QC Quality Control)	Operation Description QC8- Inspect parts - secon	nd check		Set Up/ Run Hours AS 0.00 27 9-89	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
130 *120* Brake NC Brake NC		Memo 1-Deburr 2-Form using	DT8254 as	s per Dwg D341	0.00 0.00		DAS 30 9-89		21				14/03	10
140 *1 \(\tau \) Large Fab Large Fab		Memo 1- Weld using A/R S.S. we	g location J lding rod B	ig DT9625 as pe atch: <u>↑ 1 7 </u>	0.00 0.00 or Dwg D3414				, 24		A.		1-5-5	

DQA:		_ Date:			_							•	$^{\prime\prime}$ aaa $^{\prime\prime}$
					WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only		
Work Order	•				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	·			_	Rework			Skid-tube	Crosstube	1	Water Jet		Engineering
Part No).				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
					Use-as-is			noforming	Finishing	-	e/Packaging		Other
NCR No)				Suspected Unapproved			Large Fab	Composite]	Supplier		
Root	1			Desc	ription of work order update	Н	nitial	Acti	<u>on</u>	Sign &		-т	****
Cause	Date	Step	Qty	Desc	or non-conformance		ief Eng	i		Date	Verificatio	,	QC Inspector
Design	Juce	эсер	Ψ.,	· · · · · · · · · · · · · · · · · · ·	or non comormance	-	iici Eiig	Descri	ption	Date	Vermeation		<u>Qe mspector</u>
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<u> </u>	Bending				Bend		4	Program		Outside Dim		Ш	Pressure/Forced
-	Centre N	ot Concer	ntric	\perp	BOM/Route		Grain			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect	L.	Hardwa	are		Part Incorred	ાં	Ц	Temperature/Cure
!		nk/Ripple	:/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Щ	Weld
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	Crushing			_	Countersink		4 '	gned/off center		Positioned V	_		
	Heat Tre			<u> </u>	Cut Too Short		Mislabe		L	Power Loss/	Surge		Other
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<u> </u> _	Marks/Cl			_	Drill Holes	L	Off-set						
-	_	Sequence		_	Finish		-{	Calibration					
I'	Wave/Tv	vist in Tub	oe -		Fit/Function	1	Out of	Seauence					

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Work Ord March-07-14 3		4487			*112	1487*							Page 3
Item ID: Revision ID: Item Name:	D3414-041 Lug				Accept	*N900	040	1100	7* 5	Setup	Start Stop	171	S1* S2*
Start Date: Required Date Reference:	07/03/2014 : 28/03/2014	Start Qty: 24.00 Req'd Qty: 24.00		*94* *94*		Cust Item I Customer:	D:					ı u	17
Approvals: I Sequence ID/	Process Pla	nn:	Date:		Tooling: SPC (Y/N):		nte:		R	Run	Start Stop	"IV	R1* R2*
Sequence ID/ Work Center I 150 *150* QC Quality Control	D	Operation Description QC9- Inspect visual per C	OSIOO4- Fusio	on Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty	I	Reject Number 5-05	Insp. Stamp DAS 9 9-86
*160 *160* QC Quality Control		QC5- Inspect part comple	teness to step	on W/O	0.00				_&)	<u>iu-0</u>	<u>5-05</u>	DAS 9 9-89

DQA:			Date:			WORK ORDER NON		201501	3344410F / II	DD 4 TF				DART
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RMANCE / U	PDATE	W	ork Order up	odate only	AEROSPACE
						DISPOSITION			· · · · · · · · · · · · · · · · · · ·	AGAINST		PARTMENT		
Work Orde	er: _					DISPOSITION				AGAINST	<i>D</i> E	PARTIVICIVI)	/PROCE33	
Part N	lo.					Rework Scrap		, 1	Skid-tube Machining	Crosstube Small Fab	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	- lo					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Sto	re/Packaging Supplier	Other
Root					Desci	ription of work order update	ı	nitial	Act	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design Doc/Data														
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Material	\dashv													
Operator	\dashv													
Offset/Setup														
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Transport										r				
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				_			FAI	ULT CAT	TEGORY					
Landi	ng G	iear				General								
	$\overline{}$	Bending				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred		Temperature/Cure
		Crimp/Kink/Ripple/Wave Burrs				Burrs		Inspect	ion Incomplete/Ui	ngualified		Part Lost/Mi	ssing	Weld
	Cuffs Contamination				Contamination		1 '	ions Incomplete/	•	Г	Part Moved	-	Wrong Stock Pulled	
	Crushing Countersink				Countersink		1	ned/off center			Positioned V		_	
		Heat Trea	t			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	\Box	Inspection	n Strip in	Tube		Drawing		Misread	d		_	•	_	•
	П	Marks/Ch	rks/Chatter Drill Holes					Off-set						
•	П	Turning S	equence			Finish		Out of	Calibration					
•	П	Wave/Tw	ist in Tuk	ne		 Fit/Function		Out of	Seguence					

Work Ord March-07-14 3		4487		*114	.487*						Page 4	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3414-041 Lug 07/03/2014 28/03/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	Accept	*N900 Cust Item I		100	* 5	Setup Sta Sto	17	S1* S2*	
Approvals:	~ ~	Date:		Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	" " []	R1* R2*	
Sequence ID/ Work Center II 175 *175* SprayPaint Spray Painting	D	Operation Description Spray Painting per QSI005 4.2 Memo PRIME B_126934 DELFEET BLUE B_12 4611 DEFLEET CLEAR B_125325 PRIME: Start Time: 9:00 Fininsh Time: 9:30 PAINT: Start Time: 3:00 Finish Time: 2:30	-	Set Up/ Run Hours 0.00	Tool ID	Tool#	Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	.06
185 *1 Q C Quality Control		QC14- Inspect Spray Paint Memo		0.00 DAS 97 0.00 PS	8		9	24 A				

DQA:			Date:			<u>-</u>			_				TAART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPI		ork Order up	ndate only - [AEROSPACE
ar ciosca.			Dute.								· •		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	_					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab	Composite		Supplier	
Root	П				Desc	ription of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
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		Centre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	cí [Temperature/Cure		
		Crimp/Kii	nk/Ripple	/Wave		Burrs	Inspection Incomplete/Unqualified Part Lost/Missing Instructions Incomplete/Unclear Part Moved						Weld
		Cuffs				Contamination		Wrong Stock Pulled					
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong _	
]		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	_			
] [Marks/Cl	natter			Drill Holes		Off-set					
⁻		Turning S	equence			Finish		Out of	Calibration				
l,	i 7	Wave/Tu	ist in Tub	ne .		Fit/Function		Out of	Seguence			- -	

Work Orde March-07-14 3:		4487		*114	1487*				Page 5
Revision ID:	D3414-041			Accept	*N900040	100	k Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	07/03/2014 28/03/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item ID: Customer:				14.77
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 190 *100* Packaging Packaging)	Operation Description Identify as per dwg & Sto	ock Location: <u>574</u> 46	Set Up/ Run Hours 0.00	Tool ID Tool #	Code (Accept Rejectly Qty		Reject Insp. Number Stamp MAY 0.8.2014
200 *200 QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00		_	MLJ	\	105-05
								14.0	70.20

DQA:		Date:												TRACT
DA Classide		Data			WORK ORDER NON-	-CC	DNFOI	RMANCE / UF		147.	O			AEROSPACE
QA Closed:		Date:		1		_				W	ork Order up	date only		
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube		1	Water Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	o			_	Suspected Unapproved			Large Fab	Composite]	Supplier[
Root				Desci	ription of work order update		nitial	Acti	ion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	1	QC Inspector
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Landin	g Gear				General	_	7				7	F		
-	Bending				Bend	<u> </u>	1	Program			Outside Dim	+		Pressure/Forced
	Centre No	ot Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain				Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect	_	Hardwa				Part Incorre			Temperature/Cure
1		Crimp/Kink/Ripple/Wave Burrs				┕	1	ion Incomplete/Un	-		Part Lost/Mi	ssing		Weld
	Cuffs Contamination				•	L	4	tions Incomplete/U	Inclear		Part Moved	Į		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	L	1 1	gned/off center			Positioned V	- r		1
1	Heat Trea				Cut Too Short	_	Mislabe				Power Loss/	Surge	_	Other
Ļ	Inspectio		Tube		Drawing		Misrea							
Ļ	Marks/Ch				Drill Holes		Off-set							
Turning Sequence Finish Out of Calibration														***************************************
	Wave/Tw	ist in Tul	be	:	Fit/Function		Out of	Sequence						

4													
Picklist Print March-07-14 3:34:16	6 PM			<i>**</i>							11	•	Page 1
Work Order ID: 1144	187		*	11448	27*			***	·		-		(
Parent Item: D34	14-041				4-041*								
Parent Item Name: I	Lug		•	1 7. 1 -4 1					tart Date: 07/ Start Qty: 24.		=	d Date: 28 ed Qty: 24	
Comments:	PP A05.09.13Ne	w issueKJ/JLM			: 								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	118.6300	0.155	(4)			
M304S12	PGA								**			Jm	14-03-2
				Locatio	 	Loc	<u>Oty</u>	Loc Code					
				MAT01			8.63		_				
					113062 113077	7	76.13 19		-		-		
					m126309		23.5		 1	2630	- 9 -		
D3414-3		Manufactured	No			140	Each	24.0000	1	24	-		
D3414-3	t							,	**		2 15	1-5-1	
				Locatio	<u> </u> <u>n</u>	Loc	Oty	Loc Code					
				WA001	-		24		_				
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					114975 x	12							

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		Wo	ork Order up	odate only	AEROSPACE			
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS				
Part N NCR N					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Desci	ription of work order update		nitial	Act	ion		Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved					FAULT CATEGORY											
						FAI	ULT CAT	TEGORY								
Landir	Bending Bend Bend BoM/Route Broken/Damage/Defect Crimp/Kink/Ripple/Wave Cuffs Contamination Countersink Crushing Cut Too Short Inspection Strip in Tube Marks/Chatter Turning Sequence General Bend BoM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish					Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ur ions Incomplete/U ned/off center eled	-		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other				
. `		Sequence vist in Tul		-	Finish Fit/Function	\vdash	4	Calibration								

DART AEROSPACE LTD	Work Order:	114487
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

			<u>L.</u>		1	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments
Ø0.313	+0.006/-0.001	0.315"			V	Amos
1.19	+/-0.030	1.19"	_		J	
1.00	+/-0.030	1.012"			V	
3.38	+/-0.030	3.372	_		V	
5.350	+/-0.010	5.354"	_		V	
6.23	+/-0.030	6.225	-		V	
2.500	+/-0.010	2.502			V	
0.37	+/-0.030	0 375	_		V	
0.100	+/-0.010	0.100			V	
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			-		 	

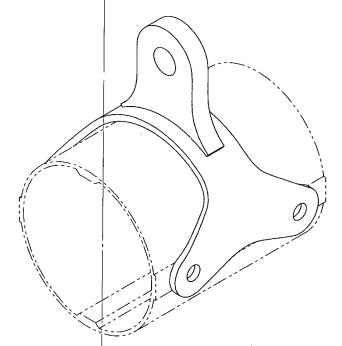
DAS

		DAS		
Measured by: JM	Audited by:	27 9-89	Prototype Approval:	N/A
Date: 14-03 - 26	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
В	09.05.27	Dimensions updated per Dwg Rev B	KJ (A	
С	09.10.16	Dwg Rev updated to Rev C	KJ X	<u> </u>

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	7	AEROSPĀCE
Work Orde	or.					DISPOSITION			AGAINS	T DE	PARTMENT,	/PROCESS		
WOIK OIG	··· —				_	Rework		Skid-tube Crosstube			1	Water Jet	Fngir	neering
Part No.				Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	_	Quality		
			-	Use-as-is			noforming Finishin	—		e/Packaging	_	Other		
NCR No.				Suspected Unapproved			Large Fab Composite	~ ├─		Supplier				
Root					Descr	iption of work order update		Initial Action			Sign &	Sign &		
Cause	_ C	ate	Step	Qty		or non-conformance	l	ief Eng			Date	Verification	QC	Inspector
Design			•											•
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Offset/Setup														
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Transport														
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	Ber	nding				Bend		Folio/F	Program	L	Outside Dim	ensions	 -1	e/Forced
:	Cer	ntre Not	Concer	ntric		BOM/Route		Grain			Over/Under	<u> </u>	Set-up	
	Cra	cks			<u> </u>	Broken/Damage/Defect		Hardwa	are	\perp	Part Incorre	ļ	Tempe	rature/Cure
	Cri	mp/Kink	:/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	_	Part Lost/Mi	ssing	Weld	
	Cut				_	Contamination		4	tions Incomplete/Unclear		Part Moved	Ĺ	Wrong	Stock Pulled
	_	ıshing			\vdash	Countersink		•	gned/off center	L	Positioned V		_ 1	
		at Treat			\perp	Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other	
		pection	-	Tube		Drawing	<u></u>	Misrea						
	lacksquare	rks/Cha				Drill Holes	<u></u>	Off-set						
	_	rning Se			\perp	Finish	$ldsymbol{f eta}$	4	Calibration					
	Wave/Twist in Tube				1	Fit/Function	1	Out of:	Sequence					

TEM No.	QTY. -041	PART NUMBER	DESCRIPTION				
1 X		D3414-041	LUG ASSEMBLY				
2	1	D3414-1	LUG BRACKET				
3	1	D3414-3	LUG				



D3414-041 LUG ASSEMBLY

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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs

114487N 1403-10

В

REV.	DESCRIPTION	BY	DATE	
Α	NEW ISSUE	CP	05.03.16	
В	DRAWING REDRAWN IN SOLLDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO 19" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PARISS). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SKAPED) FOR EASE OF MANUFACTURE. BY-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.72 DIM WAS 1.20.	AJS	08.09.23	
С	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	СР	09.06.17	

DESIGN	QP	DART AEROSPA	CELTD
DRAWN	αÞ	HAWKESBURY, ONTARIO), CANADA
CHECKED	-	DRAWING NO.	REV. C
MFG. APPR.	E	7 D3414	SHEET 1 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	4	LUG ASSEMBLY	NTS

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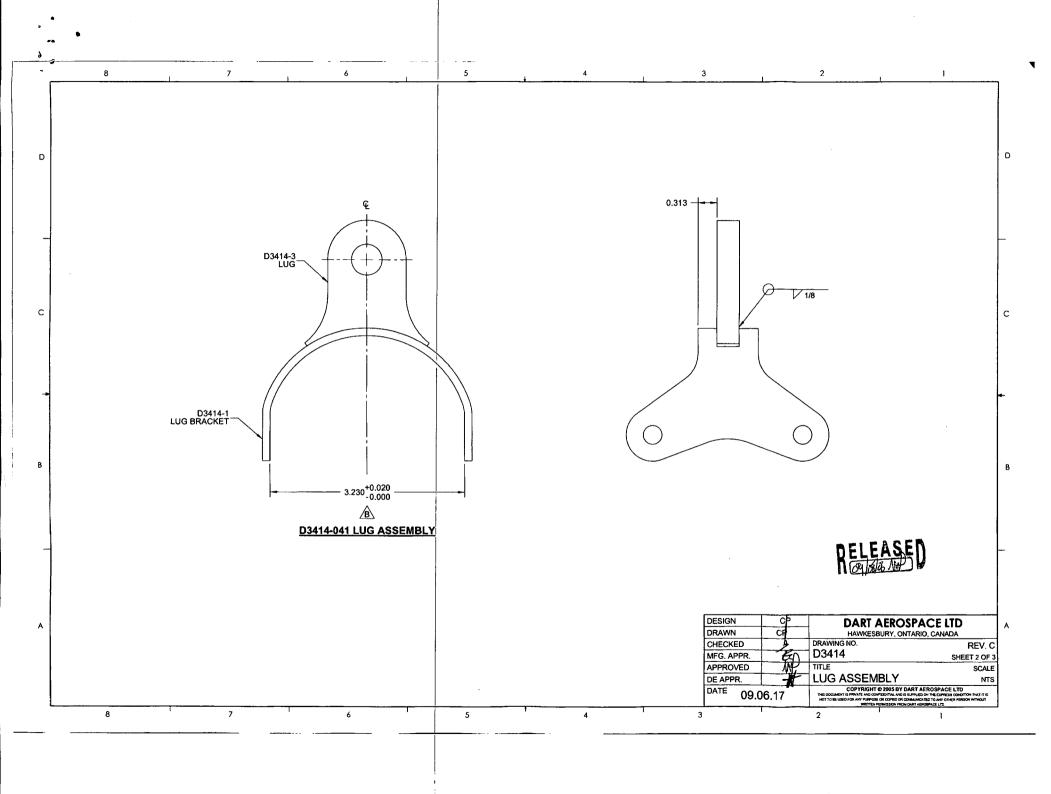
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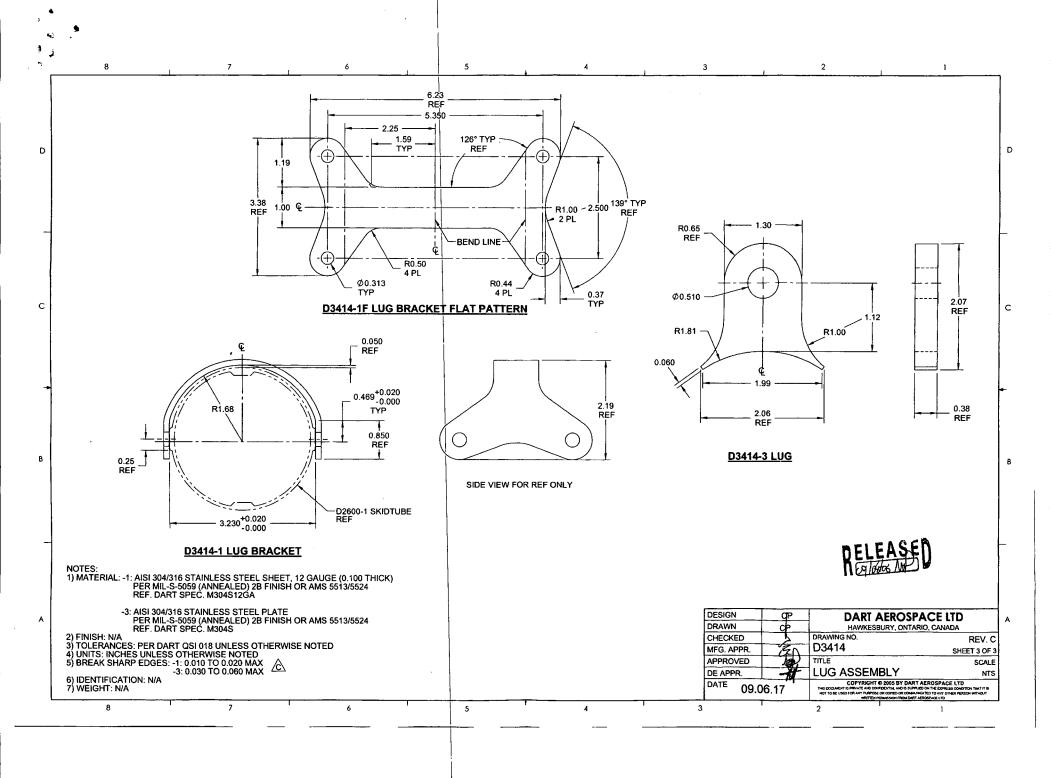
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DQA:	Date:								TRAC					
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP	DATE	W	ork Order up	odate only	$\overline{}$	AEROSPACE
	-	· · · · · · · · · · · · · · · · · · ·			DISPOSITION				ΔGΔINST		PARTMENT			
Work Orde	er:								1			•	_	,
D A	1_			-	Rework		Skid-tube Crosstube			$\overline{}$	Water Jet			Engineering
Part	Part No.				Scrap			Machining	Small Fab		1	d. Eng. Coor.	-	Quality
NCR No.				Use-as-is Suspected Unapproved		Thermoforming Finishing Large Fab Composite			_	Rec/Stol	re/Packaging Supplier	_	Other	
TVCIV I	NCR NO.				Suspected Oliappioved			raige rab	composite		<u>I</u>	Supplier	<u> </u>	ا لــا
Root	T			Desc	ription of work order update		Initial	Actio	on		Sign &	,		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion		Date	Verification	n_	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved			1											
						FA	ULT CA	regory			···			
Landi	ng Gear			_	General	_	7				-			7
	Bendin	_		oxdot	Bend		-l '	Program		L	Outside Dim		L	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route	<u> </u>	Grain				Over/Under	tolerance	L	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	i	L	Temperature/Cure
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unc	qualified	L.	Part Lost/Mi	ssing	L	Weld
	Cuffs			L	Contamination	<u></u>	Instruct	tions Incomplete/Ur	nclear		Part Moved		L	Wrong Stock Pulled
	Crushir	•			Countersink		-1	gned/off center			Positioned V	•	_	
	Heat Tr				Cut Too Short		Mislabe	eled			Power Loss/	Surge	L	Other
	Inspect	ion Strip ir	Tube		Drawing	L	Misrea	d						
	Marks/	Chatter			Drill Holes	L.	Off-set							
•	_	g Sequence			Finish		Out of	Calibration						
•	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence	•					



DQA:		Date	::										TRAGE	
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Part No				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality	
				Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other	
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	Bendi	•		-	Bend	<u> </u>	1	Program			Outside Dim		<u> </u>	Pressure/Forced
		e Not Conc	entric		BOM/Route		Grain			L	Over/Under		<u> </u>	Set-up
	Crack			<u> </u>	Broken/Damage/Defect		Hardwa			L	Part Incorre		<u> — </u>	Temperature/Cure
		/Kink/Ripp	le/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Un	*	_	Part Lost/Mi	issing	<u> </u>	Weld
	Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/U	Inclear	_	Part Moved			Wrong Stock Pulled
	Crush	·=·			Countersink	<u></u>	4	gned/off center		_	Positioned V	· ·	_	1
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		s/Chatter		\perp	Drill Holes		Off-set							
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t.	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

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DQA:		Date:	:		—							
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Part N	Part No.				Rework Scrap			Machining Sma	all Fab		d. Eng. Coor.	Engineering Quality Other
NCR N	NCR No.				Use-as-is Suspected Unapproved		Thermoforming Finishing Large Fab Composite			Rec/Stor	Supplier	J Other
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Offset/Setup		ŀ									II	
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Supplier												
Training											1	
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Unapproved												
						FA	ULT CA	TEGORY				
Landi	ng Gear				General		_					
	Bendi	ng			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centr	e Not Conce	entric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crack	S			Broken/Damage/Defect		Hardwa	are		Part Incorred	ci	Temperature/Cure
	Crimp	/Kink/Rippl	e/Wave		Burrs		Inspect	ion Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crush	ing			Countersink		Misali	gned/off center		Positioned V	Vrong	
	Heat	Treat			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
	Inspe	ction Strip i	n Tube		Drawing		Misrea	d				
	Mark:	s/Chatter			Drill Holes		Off-set					
ı	Turni	ng Sequenc	е		Finish		Out of	Calibration				
, T	Wave/Twist in Tube				Fit/Function	Г	Out of	Sequence				